



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2739

Job Sheet 207462



Part No: D2739

Job Qty: 6 pcs

Part Name: 350 I-Beam



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/26/20

Job Tracking No:

Due Date: 3/20/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D2739 REV E IPP Rev: C 02.11.28 Reformat KJ IPP Rev: D 06-03-21 As Per Rev C JLM IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev: F 10.11.02 as per revE DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Skidtubes - 1	6 pcs		3/20/20	0.00	6.96	Skidtubes - 1		00
						3.65	Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
110	QC 5	6 pcs		3/20/20	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
120	Handfinish - 1-1 Chemical-B4B	6 pcs		3/20/20	0.00	1.20	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		MAR 19 2020
							Handfinish - 1 - 4 - B4B		



Container No: S262991



Part: D2739

Job No: 207462

Serial No/Batch: S262991

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/12/20

Plex 2/26/20 1:21 PM Dart.lajeunesse.marie

				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
130	QC 7	6	3/20/20	0.00 0.00	QC 7 - 10
		pcs			QC 7 - 13
					QC 7 - 14
					QC 7 - 15
					QC 7 - 17
					QC 7 - 18
					QC 7 - 19
					QC 7 - 2
					QC 7 - 28
					QC 7 - 3
					QC 7 - 30
					QC 7 - 34
					QC 7 - 36
					QC 7 - 37
					QC 7 - 41
					QC 7 - 47
					QC 7 - 48
					QC 7 - 51
					QC 7 - 58
					QC 7 - 59
					QC 7 - 60
					QC 7 - 9
					QC 7 - 68
					QC 7 - 50
					QC 7 - 67
					QC 7 - 40
					QC 7 - 24
					QC 7 - 43
					QC 7 - 61
					QC 7 - 81

				QC 7 - 76	
				QC 7 - 79	DD
				QC 7 - 83	
				QC 7 - 82	
140 Packaging 3-1 - Stock - B4B	6 pcs	3/20/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	DD
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
150 QC 21 - SA	6 pcs	3/20/20	0.00 0.00	QC 21 - SA - 21	945
				QC 21 - SA - 70	21
				QC 21 - SA - 53	945

Part Op 100 - (Skid tubes) 1-Cut D2600-5 to length as per Dwg D2739. 2-Drill pilot holes in web using drilling Jig DT8152 as per Descriptions: Dwg D2739 3-Use uni-bit to open holes to finish size as per Dwg D2739. 4-Bevel Fwd end of extrusion and Deburr holes and ends.

110 - QC5- Inspect part completeness to step on W/O

120 - (Chemical Conversion Coat per QSI005 4.1)

130 - (QC7- Inspect Chemical Conversion Coat)

140 - (Identify as per dwg & Stock Location: _____) LOCATION : LG002

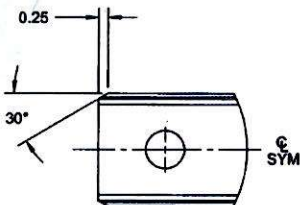
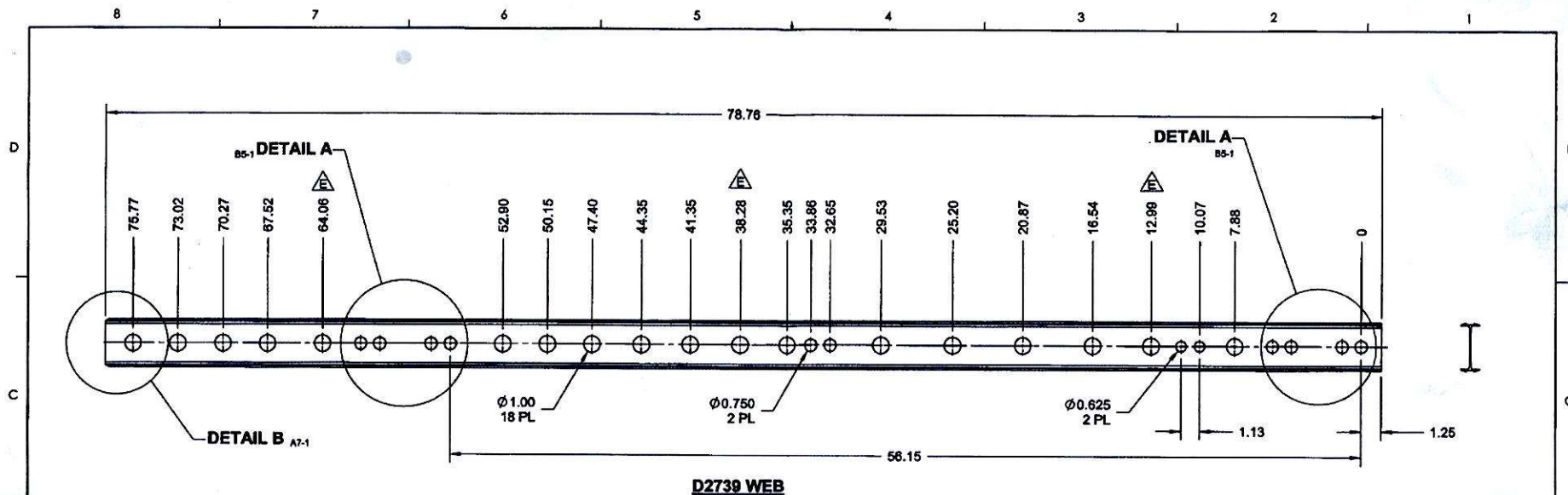
150 - (QC21- Final Inspection - Work Order Release)

MAR 19

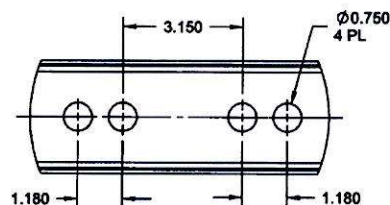
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2600-5-108	Extrusion I-Beam Thin	6 pcs (1 ea)	100-Skid tubes - 1	5146223

Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Skidtubes - 1	D2600-5-108	6	118	0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Web	78.760Inches ± 0.030	78.790 78.730		
2	Web	1.180Inches ± 0.010	1.190 1.170		
3	Web	3.150Inches ± 0.010	3.160 3.140		
4	Web	1.180Inches ± 0.010	1.190 1.170		
5	Web	0.250Inches ± 0.030	0.280 0.220		
6	Web	30.000Degrees + 0.500 - 5.000	30.500 25.000	Angle	
7	Web	1.250Inches ± 0.030	1.280 1.220		
8	Web	7.880Inches ± 0.030	7.910 7.850		
9	Web	10.070Inches ± 0.030	10.100 10.040		
10	Web	12.990Inches ± 0.030	13.020 12.960		
11	Web	16.540Inches ± 0.030	16.570 16.510		
12	Web	20.870Inches ± 0.030	20.900 20.840		
13	Web	25.200Inches ± 0.030	25.230 25.170		
14	Web	29.530Inches ± 0.030	29.560 29.500		
15	Web	32.650Inches ± 0.030	32.680 32.620		
16	Web	33.860Inches ± 0.030	33.890 33.830		
17	Web	35.350Inches ± 0.030	35.380 35.320		
18	Web	38.280Inches ± 0.030	38.310 38.250		
19	Web	41.350Inches ± 0.030	41.380 41.320		
20	Web	44.350Inches ± 0.030	44.380 44.320		
21	Web	47.400Inches ± 0.030	47.430 47.370		
22	Web	50.150Inches ± 0.030	50.180 50.120		
23	Web	52.900Inches ± 0.030	52.930 52.870		
24	Web	64.060Inches ± 0.030	64.090 64.030		
25	Web	70.270Inches ± 0.030	70.300 70.240		
26	Web	73.020Inches ± 0.030	73.050 72.990		
27	Web	75.770Inches ± 0.030	75.800 75.740		
28	Web	56.150Inches ± 0.030	56.180 56.120		

Plex 2/26/20 1:21 PM Dart.lajeunesse.marie



DETAIL B
SCALE 3X



DETAIL A
SCALE 3X

- NOTES:
- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: DART P/N "D2739" AND B/N PER DART QSI 044 6.1
 - 7) WEIGHT: 3.41 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 207462

MLJ
2002-26

RELEASED
2010-11-01

E	ADD/MOVE HOLES FOR D4154 WEARPLATE: 38.28 WAS 38.35 (DS-1), 64.06 WAS 64.77 (D7-1), ADD HOLE (DS-1)	CP	10.10.08
D	ADD BEVEL TO FWD END; ADD DETAIL B	CB	07.05.29
C	ADD/MOVE HOLES FOR COMPATIBILITY WITH APICAL FLOATS	PH	06.01.05
B	CHANGE HOLES FOR COMPATIBILITY WITH AIRCRAUISER FLOATS	CP	98.11.18
A	NEW ISSUE	DS	98.04.10
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	JP		
CHECKED	JP	DRAWING NO.	REV. E
MFG. APPR.	JP	D2739	SHEET 1 OF 1
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	WEB	NTS
DATE	10.10.08	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____ _____ _____					